PTO

DQA:	Sh	_ Date:	14/03	07	, WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	Ē			DART	
QA Closed: C	X	Date:	14/	2/25						ork Order up	date only		
Work Orde	Work Order: 1/2385 DISPOSITION						AGAINST DEPARTMENT/PROCESS						
	Part No. D3J35 - Scrap Use-as-is				Rework Scrap Vse-as-is Suspected Unapproved			Skid-tube Cross  Machining Sma  noforming Fini  Large Fab Comp	Engineering Quality Other				
Root Cause	Date	Step	Qty	Descr	iption of work order update or non-conformance	l	nitial ief Eng	Action Description	· <u>-</u>	Sign & Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport	- (c) 14	. HO	)	8	ich set on		) 	Dostrayal No No we wight who catri in of war		Ae 14-02-18	DAS 27 19-89 14 3/18	27 27 29 14/2/18	
Unapproved	l		<b></b>	W0		FA	JLT CA	TEGORY		<u> </u>		1	
Landin	g Gear				General								
	Bending Centre N Cracks Crimp/K Cuffs Crushing Heat Tre Inspectic	lot Concei ink/Ripple 3 eat on Strip in	e/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled	d	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
[	Wave/Twist in Tube Fit/Function				Out of	Sequence							

Work Orde				*112	2385*					Page 2		
Revision ID: Item Name:	D3535-25 Wearplate Ce 1/30/14 1/30/14	Start Qty: 8.00 Req'd Qty: 8.00	* <u>8</u> *	Accept	*N900  Cust Item I  Customer:		100	<b>)</b> *	Setup	Start Stop	I VI	S1* S2*
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center II 130 *120* Brake NC Brake NC	)			Set Up/ Run Hours 0.00 0.00 0.3535 using Jigs DT8261a 3535 using Jig DT8158Ido	entify as D3535-25	Tool #  DAS 30 9-89	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
140 <b>*1 4 1 * * * * QC</b> Quality Control		QC5- Inspect part comp	oleteness to step on W/O	0.00 14/2	18			9				·

150

\*150\* Powdercoat

Powder Coating

0.00

9. \$ H-2-18.

DQA:			Date:									TO A DT		
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:	_						W	ork Order up	date only		
Manda Onda						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orde	er: -				-	Daaul	,		Skid-tube Crosstube		i	Water Jet	$\neg$	Engineering
Part N	Part No.			Rework Scrap		Machining Small Fab			Pro	Prod. Eng. Coor. Qua				
, 410,	٠٠.					Use-as-is	1		noforming Finishing	-	1	e/Packaging	ᅱ	Other
NCR N	lo.				i	Suspected Unapproved	1	''''	Large Fab Composite	⊢	1	Supplier	$\neg$	H
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Landi	$\overline{}$	1				<b>General</b> Bend		]/r	Program		Outside Dim	onsions [	_	Pressure/Forced
	Н	Bending Centre No	at Cancar	atric	-	BOM/Route	$\vdash$	Grain	Togram	-	Over/Under	<u> </u>	-	Set-up
	-	Cracks	or concer	itric	-	Broken/Damage/Defect	-	Hardwa	ara		Part Incorred	-	$\dashv$	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Binnle	/M/ave	-	Burrs	-	4	ion Incomplete/Unqualified	-	Part Lost/Mi		_	Weld
	$\vdash$	Cuffs	ny rappie	, wave	-	Contamination	-	4	tions Incomplete/Unclear	-	Part Moved		$\dashv$	Wrong Stock Pulled
	$\vdash$	Crushing				Countersink	<b>—</b>		gned/off center	-	Positioned V	<b>-</b>		ong otook i anca
	$\vdash$	Heat Trea	at		$\vdash$	Cut Too Short	-	Mislab	<del>-</del>	$\vdash$	Power Loss/		$\neg$	Other
		Inspection		Tube	-	Drawing		Misread			1. 22. 22337	0 -		
	-	Marks/Chatter Drill Holes		Off-set										
	Г	Turning Sequence Finish			Out of Calibration									
	Wave/Twist in Tube				Fit/Function		Out of Sequence							

Work Orde January-30-14				*11	2385*			-				Page 3
Item ID: Revision ID: Item Name:	D3535-2			Accept	*N900	າດ4ດ <sup>.</sup>	100	* S	Setup	Start Stop	*N.	S1*
	1/30/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item Customer					•	^IVI:	<b>ラン</b> *
Approvals:		Plan:	Date:	Tooling: SPC (Y/N):		Date:		F	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC3- Inspect Part Finish			<b>AS</b>	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*1 AO* QC Quality Control		Memo			27 3-89 2))9		-	<u> </u>				
170 <b>*170*</b> Packaging Packaging		Identify as per dwg & St <b>Memo</b>	ock Location: FP	**************************************			-	<i>X</i> 9	-	<u>d</u>	<u> </u>	14/02
<sup>180</sup>		QC21- Final Inspection	- Work Order Release	0.00				4.		14	02-1	9
QC Quality Control		Memo		0.00			-	/9L	ر	<u>r_</u> f	00	

MLJ 1402-19

DQA:			Date:			_ ~APT									
			D-4			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only									
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	•					Rework	1		Skid-tube Crosstube		]	Water Jet		Engineering	
Part N	No.					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	目	Quality	
	-					Use-as-is			noforming Finishing		-1	re/Packaging		Other	
NCR N	No.					Suspected Unapproved			Large Fab Composite			Supplier			
							Ш				<b>T</b>				
Root		_			Desc	ription of work order update	l	nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector	
Design															
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Handling/Pre	Н							ह <b>क</b> प							
Material Operator	Н														
Offset/Setup	Н														
Process															
Supplier	П			!											
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		Bending				Bend		Folio/F	Program	L	Outside Dim	ensions		Pressure/Forced	
		Centre No	ot Concer	ntric	L	BOM/Route	$ldsymbol{ld}}}}}}$	Grain		L	Over/Under	tolerance	_	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa			Part Incorre		$\rightarrow$	Temperature/Cure	
		Crimp/Kii	nk/Ripple	/Wave		Burrs		1 '	ion Incomplete/Unqualified	$\perp$	Part Lost/Mi			Weld	
	L	Cuffs				Contamination		4	tions Incomplete/Unclear	L	Part Moved	_		Wrong Stock Pulled	
		Crushing				Countersink		1 `	gned/off center	_	Positioned V				
		Heat Trea			$\perp$	Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	Surge [		Other	
	_	Inspectio	-	Tube	$\perp$	Drawing	<u></u>	Misrea							
		Marks/Chatter Drill Holes		Off-set											
				Finish	<u></u>	-	Calibration								
	Wave/Twist in Tube		1	Fit/Function	1	Out of	Sequence								

# **Picklist Print**

January-30-14 11:38:24 AM

Work Order ID:

112385

Parent Item:

D3535-25

**Parent Item Name:** 

Wearplate Center

**Start Date:** 1/30/14

Required Date: 1/30/14

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified Bv:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	188.5500	0.51	4.2947368		1	
304/316 .040 Sheet												qe 1	4.02.
				<b>Location</b>		Loc Oty	Lo	c Code					
				MAT020		188.55							
				m1268	852	3.55							
				m1274		185			12	7454	$\longrightarrow$	4.3	

DQA:			Date:										TAART		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP		fauls Oudanss	.daka ambi	AEROSPACE		
QA Closed:			Date:				-			V	ork Order up	date only			
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	•					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering		
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•					Use-as-is	1		noforming	Finishing		re/Packaging	Other		
NCR N	۱o.					Suspected Unapproved	1 1		Large Fab	Composite		Supplier			
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspector		
Design							Ì								
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Handling/Pre	Щ														
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Unapproved	<u> </u>	<u> </u>			<u> </u>		ΕΛ	III T CA	I TEGORY			<u>                                     </u>			
Landi	na (	Goar				General		OLI CA	ILGORI	***					
Land	_	Bending			Г	Bend		Teolio/F	Program		Outside Dim	ensions [	Pressure/Forced		
		• -	ot Concer	ntric		BOM/Route	-	Grain	106.4	-	Over/Under	<u> </u>	Set-up		
		Cracks	or conce		<b> </b>	Broken/Damage/Defect	$\vdash$	Hardwa	are	-	Part Incorre	<u> </u>	Temperature/Cure		
		Crimp/Ki	nk/Ripple	/Wave		Burrs		4	ion Incomplete/Unc	gualified	Part Lost/Mi	<b>—</b>	Weld		
		Cuffs	,,	,		Contamination		<b>-</b> i '	tions Incomplete/Ur	· -	Part Moved	<del> </del>	Wrong Stock Pulled		
		Crushing			-	Countersink		_	gned/off center		Positioned V		<b></b>		
	$\vdash$	Heat Trea				Cut Too Short		Mislab		ļ-	Power Loss/		Other		
		Inspectio		Tube		Drawing		Misrea				_	•		
		Marks/Cl	•			Drill Holes		Off-set							
		Turning Sequence Finish				Out of	Calibration								
	Wave/Twist in Tube Fit/Function			Fit/Function		Out of	Sequence								

DART AEROSPACE LTD	Work Order:	112385
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

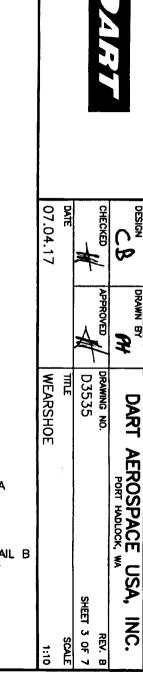
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	_		¥	JKM-05
1.937	+/-0.010	1,937	-		V	
1.450	+/-0.010	1.450	-		V	
5.450	+/-0.010	5.450	_		V	
10.900	+/-0.010	10.900	_		て	JKM-06
16.350	+/-0.010	16.350	_		Т	
21.800	+/-0.010	21.800	_		T	
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6.75	+/-0.030	6.75	_			
6.00	+/-0.030	6.00			7	
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			DAS			

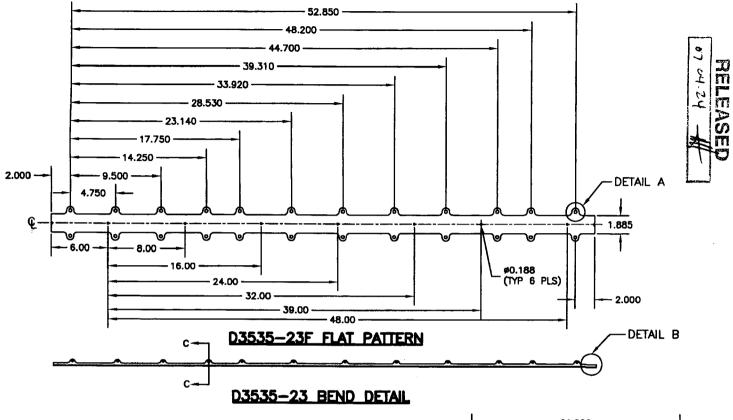
Measured by: Ac Audited by: 3-89 Prototype Approval: N/A

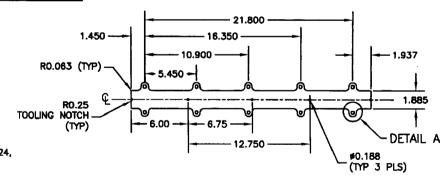
Date: 14.02.13

Date: 14.02.13

Rev	Date	Change	Revised by Approved
Α	07.11.23	New Issue	KJ/EC/DD
			, ()







1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

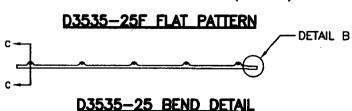
3) PART IS SYMMETRICAL ABOUT &

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX

8) SEE PAGE 7 FOR DETAILS AND SECTION



IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

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CHECKED

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DART

AEROSPACE PORT HADLOCK,

USA,

NC.

SHEET

4 OF 7

1:10

REV.

DRAWING NO.

07.04.17

WEARSHOE



D3535-31 BEND DETAIL

D3535-31F FLAT PATTERN

22.500 19.000

14.250

9.500

6.000

2.000

1.885

24.500
21.000
15.250
9.500 ——
2.000 —
6.00 - 6.75 - DETAIL A
1.885 — 13.50 — Ø0.188 (YP 3 PLS)
D3535-33F FLAT PATTERN

	_

DETAIL A

**≠**0.188 (TYP 3 PLS)

D3535-33 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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PURPOSE

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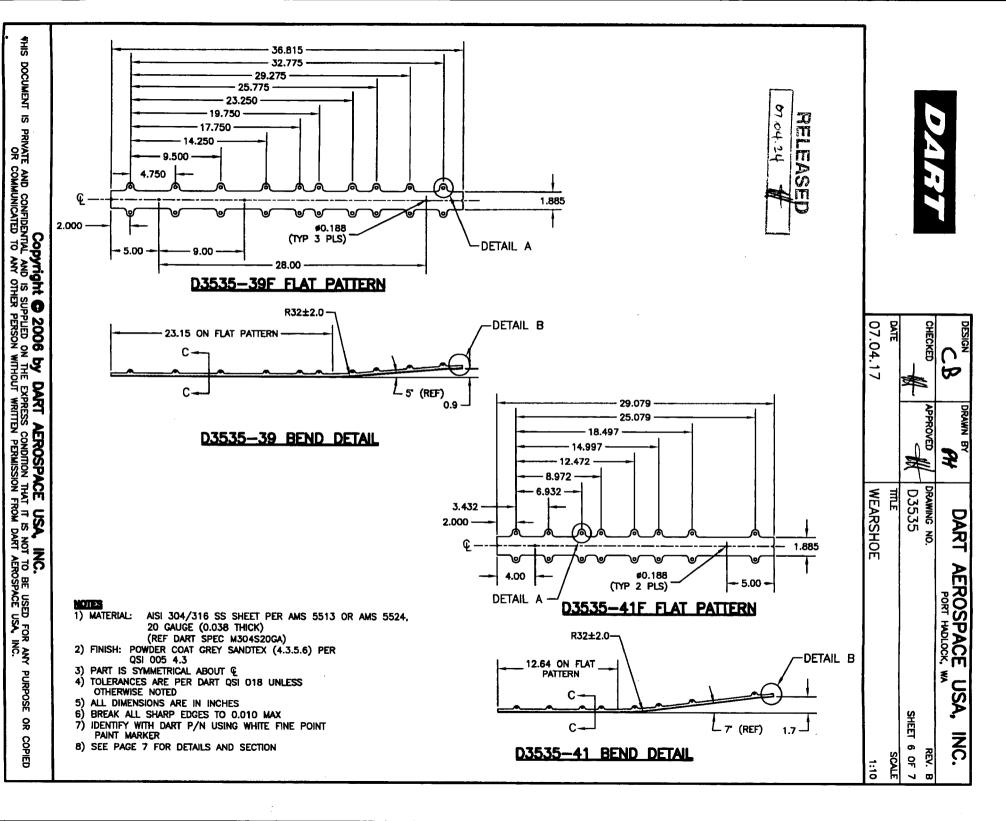
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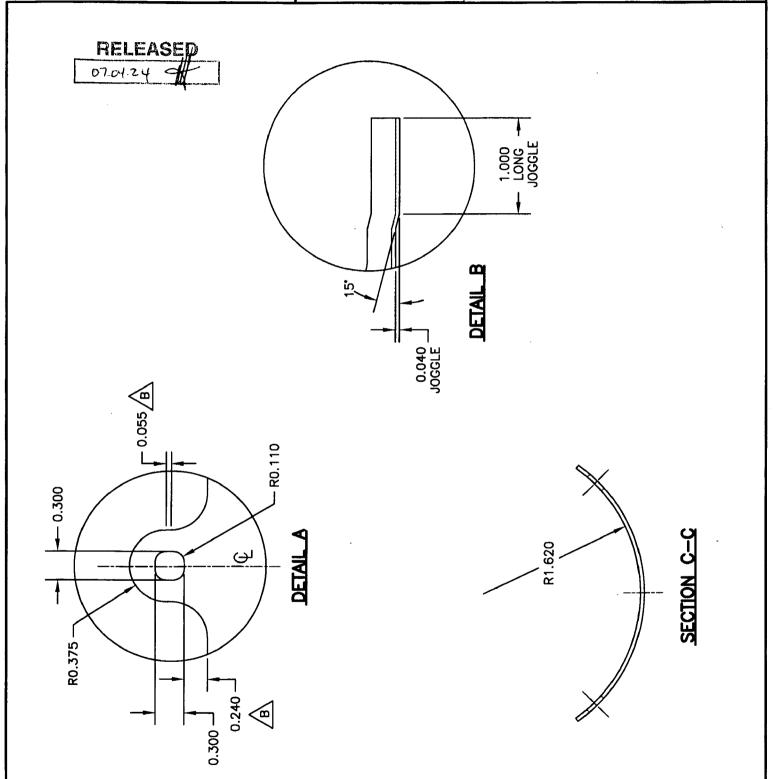
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DATE 07.04.17 CHECKED B APPROVED B D3535 DRAWING NO. WEARSHOE DART **AEROSPACE** PORT HADLOCK, JSA, SHEET ₹ C. 5 OF 7 RP. SCALE 1:10





DESIGN B	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED 44	APPROVED/	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE	4-1	TITLE	SCALE
07.04.17		WEARSHOE	1:1



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